

Date: Wednesday, 1/18/2006 4:05:38 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 25557E				
Estimate Number	: 10283				
P.O. Number	: N/A		Part Number	: D31991	
This Issue	: 1/18/2006 S.O. No. : N/A		Drawing Number	: D3199 REV A1	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A1	
Previous Run	: 25556E		Material	: N/A	
Written By	: SEE COMMENT BELOW		Due Date	: 2/15/2006	
Checked & Approved By	: SEE ABOVE USER & DATE		Qty:	36 Um: Each	
Comment	: Est Rev:C Removed Scribing 05-11-05 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: <u>00000450</u> <i>AK</i> <u>06/03/09</u> Email or Ship DXF file to vendor Laser Cut D3199-1 bracket per Dwg D3199 Material release note is required
2.0	D31991F	Bracket
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 36.0000 Each(s) Bracket
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached
4.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK <i>106/03/09</i> <i>(50)</i> <i>06.03.14</i>
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1-Deburr if necessary <i>5AD 06/03/20</i> 2-Form as per Dwg D3199 <i>N/A - Already Formed.</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:05:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BRACKET
Job Number: 25557E		Part Number: D31991
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5 	INSPECT WORK TO CURRENT STEP  <i>16/03/20</i>
Comment: INSPECT WORK TO CURRENT STEP		
7.0	POWDER COATING 	POWDER COATING 
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 <i>DL 06/03/20 (50)</i>		
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>M 06/03/21 (50)</i>		
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>138</i> <i>P-4/3/21 (50)</i>		
10.0	DC 	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Inspection Level 21 <i>06/03/23 (50)</i>		
Job Completion 		<i>W 06/03/22</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

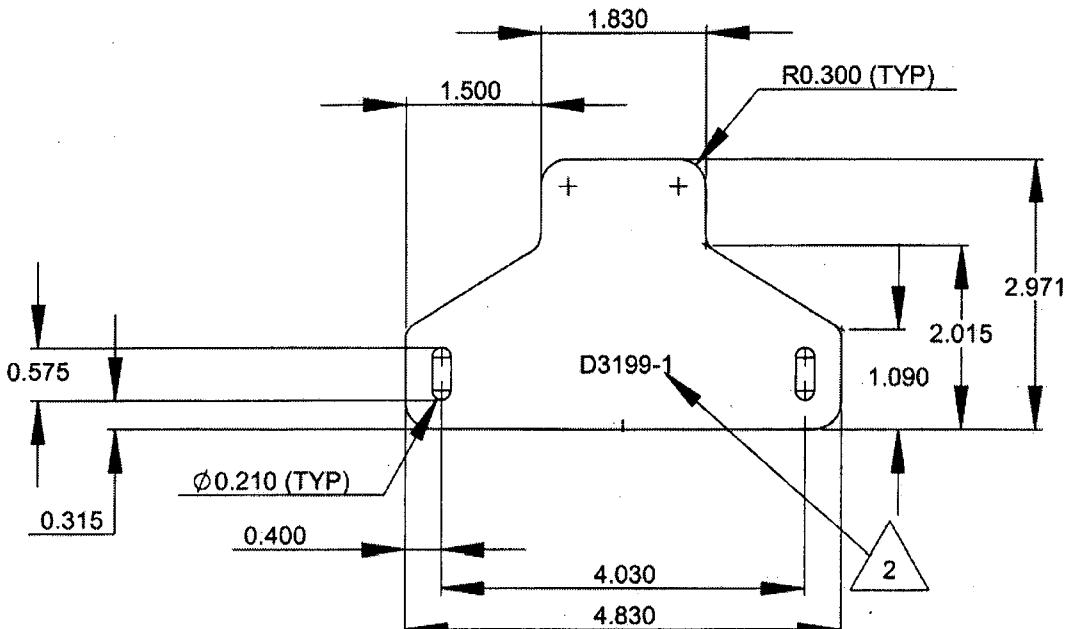
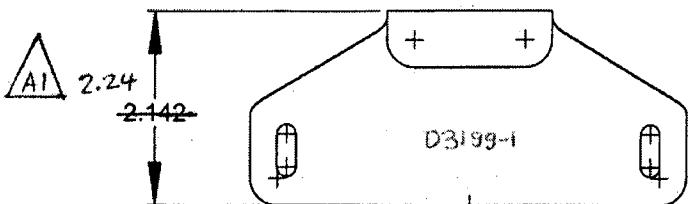
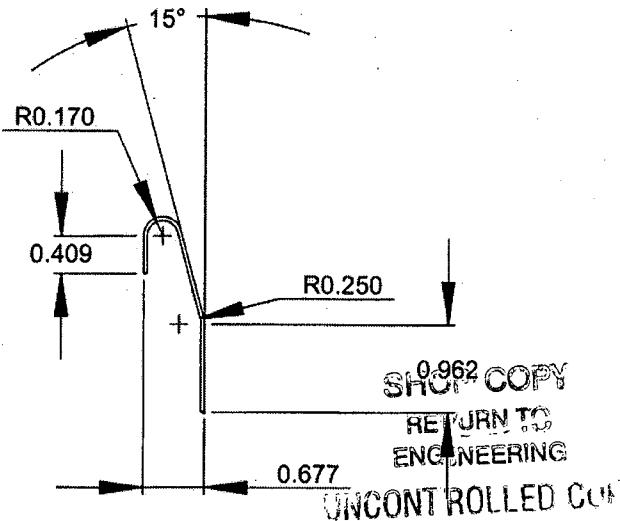
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3199
DATE	03.08.05	REV. A SHEET 1 OF 1
		SCALE 1:2
A	03.08.05	NEW ISSUE
A1	04.03.01	2.24 WAS 2.142

RELEASED
03.09.02**D3199-1 FLAT PATTERN****D3199-1 BRACKET****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) SCRIBE DART P/N D3199-1 AS SHOWN.
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES.

WORK IN PROGRESS

25557E

SUBJECT TO AMENDMENT

P50210PC002

DX-N-NC
1075-07
Informed by telephone

ThyssenKrupp Acciai Speciali Terni S.p.A.
 Via Michele De Mattei 10
 21045 Varese (VA)
 Italy - Tel. +39 036 50 10 00

14275002

ASTM A 240/DIA
 ASME SA 240/B1

CERTIFICATO DI COLLAUDO
INSPECTION CERTIFICATE
CERTIFICATE DE RECEPTION
ABNAHMEPRÜFZEUGNIS

22 10204/3.1B

0433464

PAG. 1/1



THYSSENKRUPP ACCIAI SPECIALI TERNI
 10 BANK STREET - WHITE PLAINS
 NEW YORK
 10606 USA

8H73/1075

CLIENTE
 DISTRIBUIDOR
 COMERCIO
 CONSUMO
 APPLIANCE

ONDE MATERIALE
 AVVISTAMENTO
 CONFORMITÀ
 TESTIMONIO

AVVISTAMENTO
 AVVISTAMENTO
 AVVISTAMENTO

SE040532

OLBERT METAL SALES LTD
 989 DERRY ROAD EAST SUITE 305
 MISSISSAUGA, ONTARIO L5T 2R8
 CANADA

TUV

STAINLESS STEEL PLATES FROM COIL

N. COLO COLO N. COLO N. COLO N. COLO	N. COLO COLO N. COLO N. COLO N. COLO	COMPOSIZIONE CHIMICA - CHEMICAL COMPOSITION - COMPOSITION CHIMIQUE - COMPOSICIÓN QUÍMICA - CHEMISCHE ZUSAMMENSETZUNG													
		Si	Cr	Ni	P	S	Mo	Nb	W	Ti	Al	V	Cu	U	N
633635	0486368	.043	1.25	.33	.032	.001	18.14	0.01	.29	.046			.300		

This material does not contain Nickel of Cuban origin

521 CS INOX S.p.A.

MAX TEMPERATURE 1050°C

MAX TENSILE STRENGTH 400 MPa

MAX TORSION - SHEAR STRENGTH 100 MPa

MAX BENDING - FLEXURE 100 MPa

MAX THERMAL EXPANSION 10 ppm

PIRELLA - VARESE
 PIRO - VARESE - VARESE

PIRELLA - VARESE
 PIRO - VARESE - VARESE
 PIRO - VARESE - VARESE
 PIRO - VARESE - VARESE

L'UNIVALE è impegnata a fornire materiali e servizi di qualità secondo le norme europee EN 10020-10025-10028-10034-10035-10036-10038-10040-10045-10046-10047-10048-10050-10051-10052-10053-10054-10055-10056-10057-10058-10059-10060-10061-10062-10063-10064-10065-10066-10067-10068-10069-10070-10071-10072-10073-10074-10075-10076-10077-10078-10079-10080-10081-10082-10083-10084-10085-10086-10087-10088-10089-10090-10091-10092-10093-10094-10095-10096-10097-10098-10099-100100-100101-100102-100103-100104-100105-100106-100107-100108-100109-100110-100111-100112-100113-100114-100115-100116-100117-100118-100119-100120-100121-100122-100123-100124-100125-100126-100127-100128-100129-100130-100131-100132-100133-100134-100135-100136-100137-100138-100139-100140-100141-100142-100143-100144-100145-100146-100147-100148-100149-100150-100151-100152-100153-100154-100155-100156-100157-100158-100159-100160-100161-100162-100163-100164-100165-100166-100167-100168-100169-100170-100171-100172-100173-100174-100175-100176-100177-100178-100179-100180-100181-100182-100183-100184-100185-100186-100187-100188-100189-100190-100191-100192-100193-100194-100195-100196-100197-100198-100199-100200-100201-100202-100203-100204-100205-100206-100207-100208-100209-100210-100211-100212-100213-100214-100215-100216-100217-100218-100219-100220-100221-100222-100223-100224-100225-100226-100227-100228-100229-100230-100231-100232-100233-100234-100235-100236-100237-100238-100239-100240-100241-100242-100243-100244-100245-100246-100247-100248-100249-100250-100251-100252-100253-100254-100255-100256-100257-100258-100259-100260-100261-100262-100263-100264-100265-100266-100267-100268-100269-100270-100271-100272-100273-100274-100275-100276-100277-100278-100279-100280-100281-100282-100283-100284-100285-100286-100287-100288-100289-100290-100291-100292-100293-100294-100295-100296-100297-100298-100299-100300-100301-100302-100303-100304-100305-100306-100307-100308-100309-100310-100311-100312-100313-100314-100315-100316-100317-100318-100319-100320-100321-100322-100323-100324-100325-100326-100327-100328-100329-100330-100331-100332-100333-100334-100335-100336-100337-100338-100339-100340-100341-100342-100343-100344-100345-100346-100347-100348-100349-100350-100351-100352-100353-100354-100355-100356-100357-100358-100359-100360-100361-100362-100363-100364-100365-100366-100367-100368-100369-100370-100371-100372-100373-100374-100375-100376-100377-100378-100379-100380-100381-100382-100383-100384-100385-100386-100387-100388-100389-100390-100391-100392-100393-100394-100395-100396-100397-100398-100399-100400-100401-100402-100403-100404-100405-100406-100407-100408-100409-100410-100411-100412-100413-100414-100415-100416-100417-100418-100419-100420-100421-100422-100423-100424-100425-100426-100427-100428-100429-100430-100431-100432-100433-100434-100435-100436-100437-100438-100439-100440-100441-100442-100443-100444-100445-100446-100447-100448-100449-100450-100451-100452-100453-100454-100455-100456-100457-100458-100459-100460-100461-100462-100463-100464-100465-100466-100467-100468-100469-100470-100471-100472-100473-100474-100475-100476-100477-100478-100479-100480-100481-100482-100483-100484-100485-100486-100487-100488-100489-100490-100491-100492-100493-100494-100495-100496-100497-100498-100499-100500-100501-100502-100503-100504-100505-100506-100507-100508-100509-100510-100511-100512-100513-100514-100515-100516-100517-100518-100519-100520-100521-100522-100523-100524-100525-100526-100527-100528-100529-100530-100531-100532-100533-100534-100535-100536-100537-100538-100539-100540-100541-100542-100543-100544-100545-100546-100547-100548-100549-100550-100551-100552-100553-100554-100555-100556-100557-100558-100559-100560-100561-100562-100563-100564-100565-100566-100567-100568-100569-100570-100571-100572-100573-100574-100575-100576-100577-100578-100579-100580-100581-100582-100583-100584-100585-100586-100587-100588-100589-100590-100591-100592-100593-100594-100595-100596-100597-100598-100599-100600-100601-100602-100603-100604-100605-100606-100607-100608-100609-100610-100611-100612-100613-100614-100615-100616-100617-100618-100619-100620-100621-100622-100623-100624-100625-100626-100627-100628-100629-100630-100631-100632-100633-100634-100635-100636-100637-100638-100639-100640-100641-100642-100643-100644-100645-100646-100647-100648-100649-100650-100651-100652-100653-100654-100655-100656-100657-100658-100659-100660-100661-100662-100663-100664-100665-100666-100667-100668-100669-100670-100671-100672-100673-100674-100675-100676-100677-100678-100679-100680-100681-100682-100683-100684-100685-100686-100687-100688-100689-100690-100691-100692-100693-100694-100695-100696-100697-100698-100699-100700-100701-100702-100703-100704-100705-100706-100707-100708-100709-100710-100711-100712-100713-100714-100715-100716-100717-100718-100719-100720-100721-100722-100723-100724-100725-100726-100727-100728-100729-100730-100731-100732-100733-100734-100735-100736-100737-100738-100739-100740-100741-100742-100743-100744-100745-100746-100747-100748-100749-100750-100751-100752-100753-100754-100755-100756-100757-100758-100759-100760-1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